

# Work Order ID 69396

Wednesday, June 15, 2011 7:41:03 AM



Page 1

Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

(2 LB) Put Reg Labels on steps

Sublocals

for CL 11-6-16

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: 1109929

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: 1114695

ES 11/06/15 (2)

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Item ID: D412-630-033

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Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8 u106145					
130  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
140  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00		8 u106116					

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Item ID: D412-630-033

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Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
	Location: _____								
	PPP Rev: _____								
160		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

P4/6/15 (2)

n/6/20

MF

11-06-18

# Picklist Print

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Page 1

Work Order ID: 69396

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding




Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-08 JLM  
IPP rev B ecn 1019, added d2807-041 EC verified by:DD  
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107  Clevis		Manufactured	No			110	Each	25.0000	1	2		5/11/06/15	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005				25					
				66811				25					
D2803-041  Bracket Assembly		Manufactured	No			110	Each	6.0000	1	2		5/11/06/15	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST149				6					
				61724				3					
				64092				3					
D2804-041  Bracket Assembly		Manufactured	No			110	Each	5.0000	1	2		5/11/06/15	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST150				5					
				61726				3					
				62075				2					

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Work Order ID: 69396

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2807-041

Manufactured No

110 Each

33.0000

2

4



Door prop

Location

Loc Qty

Loc Code

ST022

33

60540

2

66336

11

69671

20



5/11/06/15

D2813

Manufactured No

110 Each

34.0000

2

4



Washer

Location

Loc Qty

Loc Code

ST023

34

61051

13

69386

21



5/11/06/15

D3562-041

Manufactured No

110 Each

1.0000

1

2



Step Assembly, LH

369398 (2x)

Location

Loc Qty

Loc Code

FG110

1

54963

1



5/11/06/15

D3395-18

Manufactured No

110 Each

52.0000

4

8



Bushing

Location

Loc Qty

Loc Code

ST052

52

68491

22

69387

30



5/11/06/15

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Work Order ID: 69396

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C2FA

Purchased

No

110

Each

93.0000

2

4



BOLT



*EP 11/06/15*

Location

Loc Qty

Loc Code

ST352

93

109148

23

117366

20

117514

50

4

AN8C16

Purchased

No

110

Each

53.0000

2

4



Bolt



*EP 11/06/15*

Location

Loc Qty

Loc Code

ST345

53

106066

53

4

AN310C8

Purchased

No

110

Each

39.0000

2

4



Nut



*EP 11/06/15*

Location

Loc Qty

Loc Code

ST324

39

111819

9

117771

30

4

MS24665-302

Purchased

No

110

Each

204.0000

6

12



Cotter Pin



*EP 11/06/15*

Location

Loc Qty

Loc Code

ST309

4

113644

4

ST357

200

117460

200

3

1

# Picklist Print

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Work Order ID: 69396

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3



Washer

Purchased

No

110

Each

148.0000

4

8



*EP 11/06/15*

Location

Loc Qty

Loc Code

ST277

148

116373

48

117460

100

*8*

NAS1515H5L



WASHER

Purchased

No

110

Each

100.0000

4

8



*EP 11/06/15*

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

60

111359

60

*8*

NAS1515H8



Washer

Purchased

No

110

Each

259.0000

4

8



*EP 11/06/15*

Location

Loc Qty

Loc Code

ST278

259

111275

59

111411

200

*8*

MS21043-3



Nut

Purchased

No

110

Each

345.0000

4

8



*EP 11/06/15*

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

273

112314

273

*6*

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Shop Packet Print

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Work Order ID: 69396

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

MS24693-C280

Purchased

No

110

Each

27.0000

2



Screw

## Location

## Loc Qty

## Loc Code

ST310

26

115594

26

ST318

1

111279

1

Manufactured

No

130

Each

22.0000

2

D2806-1



Bushing

## Location

## Loc Qty

## Loc Code

ST022

22

64074

2

68492

20

Manufactured

No

130

Each

23.0000

2

D2806-3



Bushing

## Location

## Loc Qty

## Loc Code

ST022

23

64075

3

69401

20

Manufactured

No

130

Each

16.0000

1

D2810-5



Strut

## Location

## Loc Qty

## Loc Code

ST265

16

52034

1

68493

5

69402

10

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Work Order ID: 69396

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

Sr D3396-1  
Spacer

Manufactured No

130 Each

24.0000



2

4

Location

Loc Qty

Loc Code

ST052

24

46748

24

Purchased

No

130

Each

346.0000



1

2

Sr AN4C6A  
Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

50

117313

50

ST356

292

116704

17

117619

150

117794

50

117872

75

Purchased

No

130

Each

81.0000



1

2

Sr AN4C10A  
Bolt

Location

Loc Qty

Loc Code

ST356

81

111295

4

112243

47

114523

30

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Work Order ID: 69396

Parent Item: D412-630-033


Parent Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011


Required Date: 5/16/2011

Start Qty: 2.00


Required Qty: 2.00

AN5C15A Purchased No 130 Each 73.0000 2 4  
  
 Bolt

Location	Loc Qty	Loc Code
ST339	73	
111819	23	
<del>117764</del>	25	
117885	25	

AN44C7A Purchased No 130 Each 73.0000 1 2  
  
 Eyebolt

Location	Loc Qty	Loc Code
ST362	73	
109013	33	
<del>111308</del>	40	

AN4C15A Purchased No 130 Each 125.0000 2 4  
  
 Bolt

Location	Loc Qty	Loc Code
ST358	125	
115835	25	
<del>115936</del>	2	
117441	48	
117795	50	

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Work Order ID: 69396

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H4

Purchased

No

130

Each

188.0000

7

14



Washer

Location

Loc Qty

Loc Code

ST277

188

111525

2

116169

36

117460

50

117735

100

NAS1515H5

Purchased

No

130

Each

123.0000

7

14



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

83

109430

83

MS21043-4

Purchased

No

130

Each

1,207.000

4

8



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

167

117423

167

ST301

1000

117601

500

117793

500

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Work Order ID: 69396



Parent Item: D412-630-033



Parent Item Name: Heli Access Step LH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-5

Purchased

No

130

Each

511.0000

3

6



11/6/55 20

Nut

## Location

## Loc Qty

## Loc Code

FG

20

101418

20

ST301

491

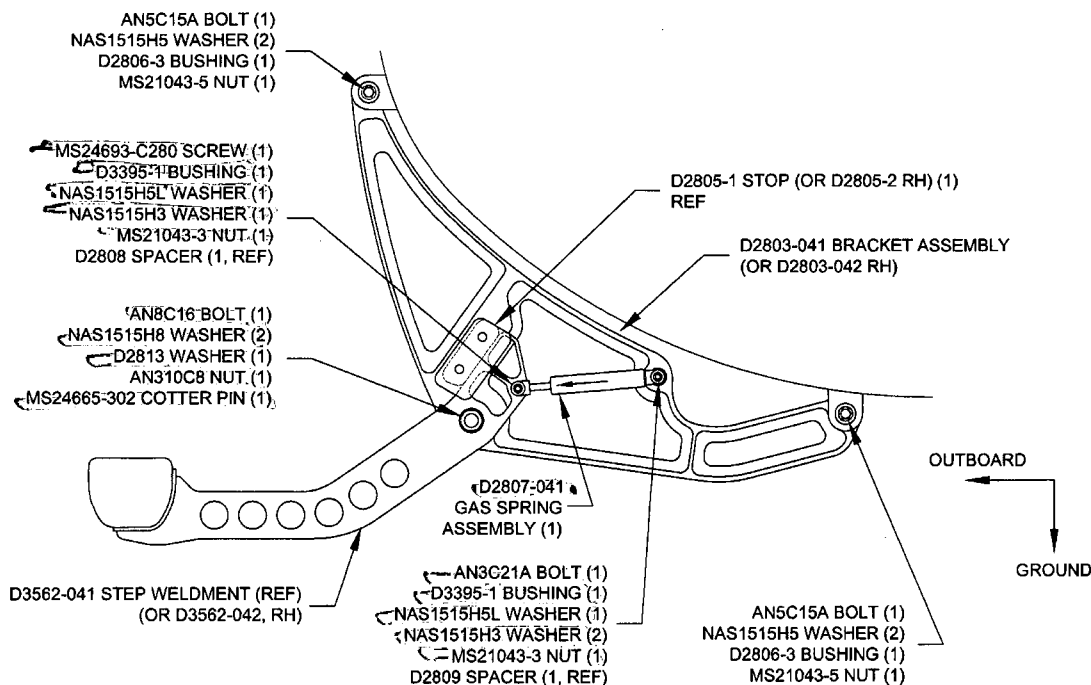
112314

391

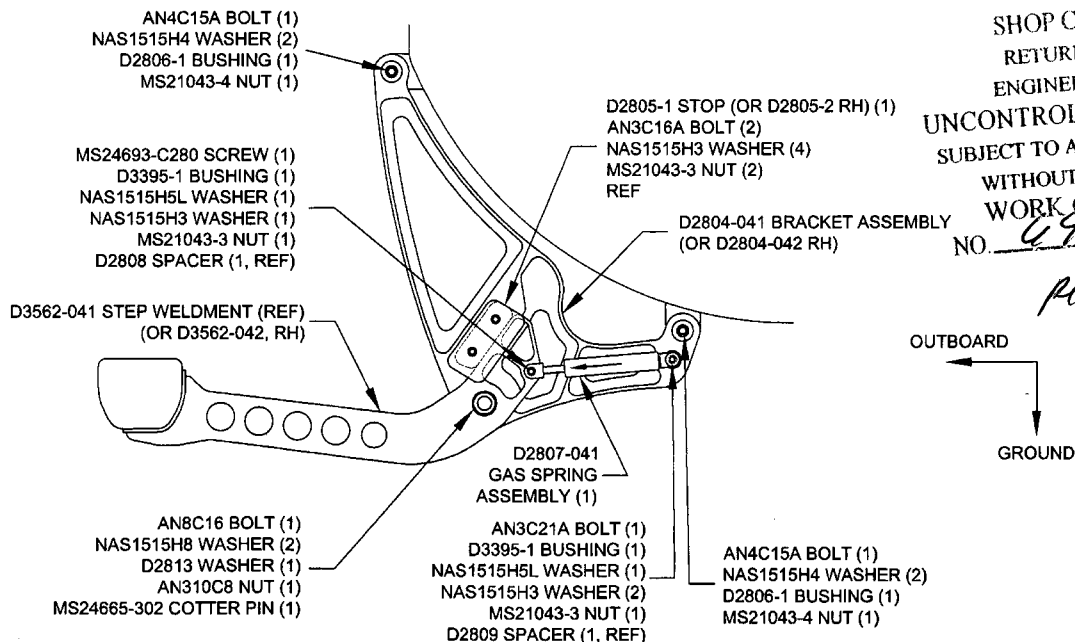
116348

100

6

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69396

*PH-05-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

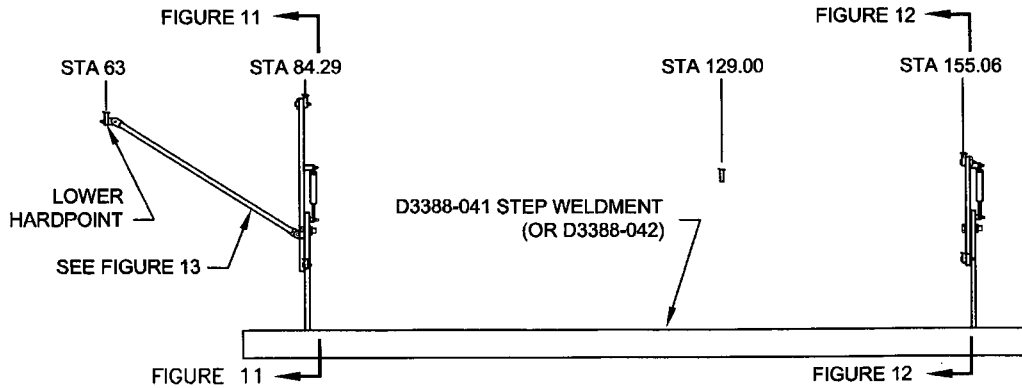
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

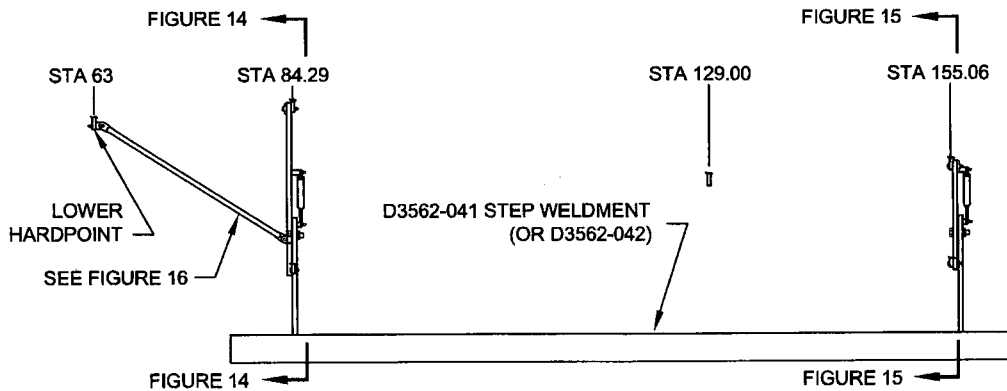
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

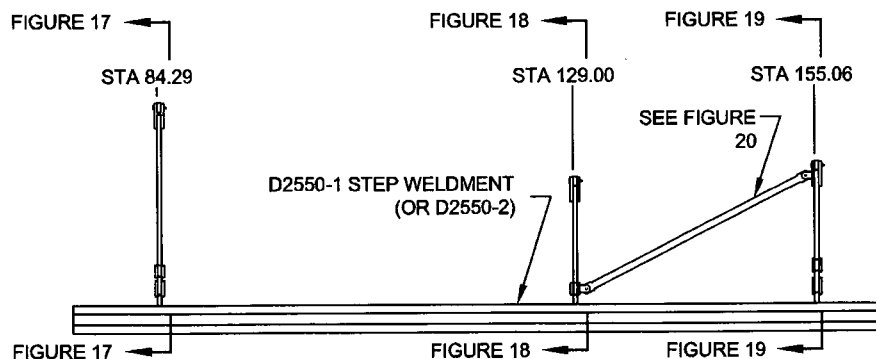
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Revision: **M**  
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
	2	2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)